

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026761**Date Inspected:** 23-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1230**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**East Line**

This QA observed, at random intervals, ABF/JV qualified welder Eric Sparks #3040 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. The joint being welded was a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 14E-PP125-E4-LLH#4 and was performed in the flat position from the top of the "A" deck plate.

During welding, ABF Quality Control (QC) Jesse Cayabyab was noted monitoring the welding parameters. Welding parameters were recorded as (A=135).

This joint is a Seismic Performance Critical Member (SPCM) member.

This QA observed, at random intervals, ABF/JV qualified welder Todd Jackson #4639 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1220A. Welding consisted of five millimeter (5mm) fillet welds to attach temporary erection aid "Haul Rope Support Frame" at panel point 111 as detailed on Sheet No: DE4470.

During welding, ABF Quality Control (QC) Jesse Cayabyab was noted monitoring the welding parameters.

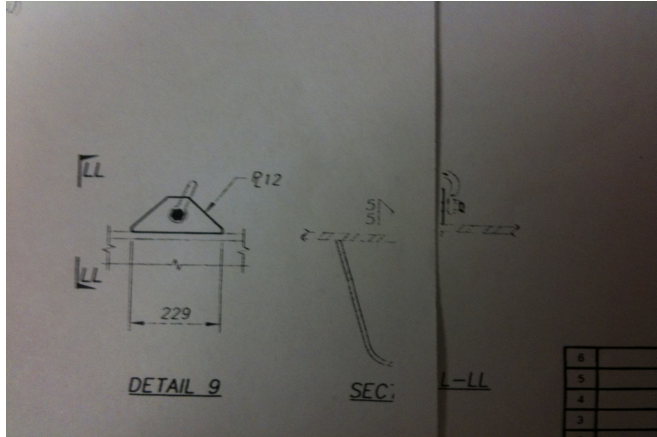
# WELDING INSPECTION REPORT

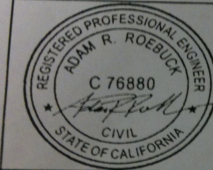

( Continued Page 2 of 2 )

Welding parameters were recorded as (A=138).

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



STATE OF CALIFORNIA DEPARTMENT OF TRANSPORTATION CONTRACT NO. 04-0120F4 BRIDGE NO. 34-0006LR			
DISTRICT 04	COUNTY SF	ROUTE 80	KILOMETER POST 13.2 / 13.9
SAN FRANCISCO OAKLAND BAY BRIDGE EAST SPAN SEISMIC SAFETY PROJECT SELF ANCHORED SUSPENSION BRIDGE (SUPERSTRUCTURE AND TOWER)			
CABLE ERECTION PLAN EAST END TRAMWAY FRAMES PP 111 FRAME OVERVIEW			
			
			
Design By: A. ROEBUCK		Date: 7/19/2011	
Design Chk: K. SMITH		Date: 7/19/2011	
Drawn By: A. ROEBUCK		Date: 7/19/2011	
Drawing Chk: K. SMITH		Date: 7/19/2011	
In Charge Of: K. BALTZER			
Job No. 660110		Sheet No. DE4470	
Scale: NTS		Revision: 1	
HMS REDESIGN OF TRAMWAY FRAMES			
DISGN CHK DESCRIPTION			

## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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